

5157814



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5086-1-116
Job Sheet 189818



Part No: D5086-1-116

Job Qty: 30 pcs

Part Name: Extrusion 116" Long



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/30/19

Job Tracking No:

Due Date: 2/28/19

Created By: Steven Hemmerich

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	30 pcs	2/28/19	2/28/19	0.00	0.00	Purchasing - 1 Purchasing - 2 Purchasing - 3	AT 1/19/28
110	Packaging 2-1 - Receive - B4B	30 pcs	2/28/19	2/28/19	0.00	0.00	Packaging 2 - 1 - B4B Packaging 2 - 2 - B4B Packaging 2 - 3 - B4B Packaging 2 - 5 - B4B Packaging 2 - 4 - B4B Packaging 2 - 6 - B4B Packaging 2 - 7 - B4B Packaging 2 - 8 - B4B Packaging 2 - 9 - B4B Packaging 2 - 10 - B4B Packaging 2 - 11 - B4B Packaging 2 - 12 - B4B Packaging 2 - 13 - B4B Packaging 2 - 14 - B4B Packaging 2 - 15 - B4B Packaging 2 - 16 - B4B Packaging 2 - 17 - B4B Packaging 2 - 18 - B4B Packaging 2 - 19 - B4B Packaging 2 - 20 - B4B Packaging 2 - 21 - B4B Packaging 2 - 22 - B4B Packaging 2 - 23 - B4B Packaging 2 - 24 - B4B Packaging 2 - 25 - B4B Packaging 2 - 26 - B4B Packaging 2 - 27 - B4B Packaging 2 - 28 - B4B Packaging 2 - 29 - B4B	AT 1/19/28

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				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120	QC 6	30 pcs	2/28/19	0.00 0.00	QC 6 - 38
					QC 6 - 42
					QC 6 - 9
					QC 6 - 68
					QC 6 - 61
130	Packaging 3-1 - Stock - B4B	30 pcs	2/28/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
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					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
140	QC 21 - SA	30 pcs	2/28/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70

DAS
61
9-89

TF 20

DAS
21
9-89

MAR 07 2019

Part Op 100 - ISSUE P/O : _____ POSSIBLE SUPPLIER: Signature Aluminum Canada Inc. MANUFACTURE AS
 Descriptions: D5086-116 AS PER DWG C OF C IS REQUIRED
 110 - (Receive & Inspect for Damage & Mat'l Certs)
 120 - (QC6- All purchased or subcontracted products)
 130 - (Identify as per dwg & Stock Location: HALL)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D5086-1-116P	Extrusion 116" Long	30 Ea (1 ea)	100-Purchasing	5157811
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D5086-1-116P	30	0	0
Part Specifications				
Specifications could not be found.				

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042405



Supplier: SIG001-VC
Signature Aluminum Canada Inc.
C/O/ T10322C
PO Box 4488, STN A
TORONTO
ON
M5W 4H1 Canada
Phone: 905-427-6550
Fax: 905-427-2246

PO No: PO042405
PO Date: 1/25/19
Due Date: 2/25/19
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1 ✓ A	189818	D5086-1-116P		Extrusion 116" Long : Various STC's AS PER DWG D5086 REV. A DIE # DAA-10	Firmed	-	2/25/19	30 Ea	0 Ea 33x	30 Ea M 1/14/2018	\$98.3654/Ea	\$2,950.96
Grand Total:												\$2,950.96

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable). No Raw Metals from China or Soviet Bloc Countries
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program.

A049 supplier awareness.

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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ACCT# 46024

1850 Clements Road, Pickering Ontario, Canada L1W 3R8

Phone: (866) 587-5780 Fax: (905) 427-2207

Visit us at www.signaturealum.com

INVOICING AND COMPANY LOCATION

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

PACKING LIST

PACKING LIST DATE / DATE DU BODEREAU	
02-25-19	
PACKING LIST NUMBER / N° DE BODEREAU	
041718	
SALES ORDER NUMBER / N° DE COM	
135071	

SHIP TO / EXPÉDIÉ À DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA PHONE: 613-632-5200	SOLD TO / VENDUE À DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA PHONE: 613-632-5200
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TERMS / FREIGHT
PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCEREFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCE

CUSTOMER ID / ID DU CLIENT 46024	ORDER DATE / DE LA COM 01/25/19	CUSTOMER PO NUMBER / CLIENT PO Nombre PO042405	BILL OF LADING NUMBER / NO. DE CONNAISSEMENT 041718		JOB / FICHIER	FIELD SALES REP / REP REGIONAL DES VENTES G.ATTENBOROU	CUST SERVICE REP / REP. SERVICE CLIENTELE D1K				
ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRECEDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO DAA-10-3	ALLOY & TEMPER / ALLIAGE & TEMPER 6061 T6	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS 1	GROSS LBS / LIVRES BRUT 1,230	NET QUANTITY / QUANTITÉ NETTE 1,213 LB	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison 558
001	1,136 LB			D5086-1-116P 116"	116.0000 IN			558	550 KG		33 PC
Y	30 PC			Cut (+): 0.1180 Cut (-): 0.0000		Min: -10 % Max: 10 %					
914712 / 474440							1	1,230	1,213		33 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives. No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on our website.

CUSTOMER

ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

Page 1 of 1

DATE OF DELIVERY

DRIVER

1	1,230	1,213 LB
	558	550 KG
		33 PC
TOTALS		

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No.	Sales Order	Page
02/13/2019	5518208	135071	1
Cust PO	B/L No	Lot	Date
PO042405	041718	914712	02/25/19

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
001	DAA-10-3	116" MILL 6061 T6	D5086-1-116P 116"
Gross Weight	1,230 LBS		
Net Qty	1,213 LBS 33 PCS 1 PKGS		
Specification	Die Desc		
AMS-QQ-A-200/8 & ASTM B221-08			

Mechanical Tests:

Tensile	Yield			
MPA / KSI	MPA / KSI	% Elongation	Conductivity	HRE
322.1 / 46.7	297.3 / 43.1	13.0	N/A	94

Chemical Analysis:

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	V	Zr
0.59	0.23	0.18	0.05	0.88	0.07	0.05	0.02	0.01	0.00

*This Material is Made in Canada**This Material is RoHS Compliant*

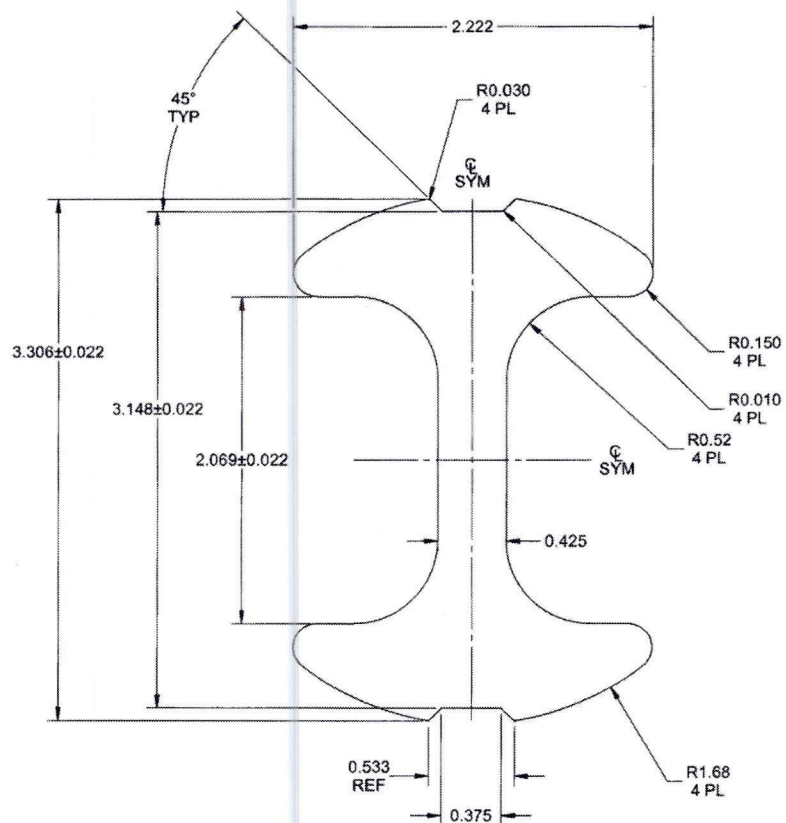
This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Gooder
Quality Manager
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

Rev A



D5086-1 EXTRUSION

GENERAL NOTES:

- 1) MATERIAL: 6061-T6 PER QQ-A-200/8 OR ASTM B221
 MINIMUM TENSILE YIELD STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
 MINIMUM ELONGATION = 8%
 A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5086-1" AND BATCH NUMBER "BNXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 3.820 lb/l
- 8) NO TOOLING MARKS
- 9) PART NUMBER IS D5086-1-XXX WHERE XXX IS THE CUT LENGTH IN INCHES WITH TOLERANCE OF +1.0 / -0.0 (EX. D5086-1-180 IS 180" LONG)
- 10) D5086-1 EXTRUSION MANUFACTURED FROM: SIGNATURE ALUMINUM DIE # DAA-10

RELEASED
 2015-06-08
 ECN 15-051

APPROVED	REV.	NEW ISSUE	AP	15.02.25
	DESIGN	AP	BY	DATE
	DRAWN	AP	DART AEROSPACE USA, INC.	
	CHECKED	DW	KENT, WA	
	MFG. APPR.	JLM	DRAWING NO.	REV. A
	APPROVED	HS	D5086	SHEET 1 OF 1
DATE	DE APPR.	DS	TITLE	SCALE
	15.02.25		EXTRUSION	NTS

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MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D5086-1-116

PO / BATCH NO.: P0042405/5157814

DATE: 19/02/2019

MATERIAL CERT REC'D: Yes

THICKNESS ORDERED: 3.306"

QUANTITY RECEIVED: 33x

THICKNESS RECEIVED: 3.306"

QUANTITY INSPECTED: 33x

SHEET SIZE ORDERED: —

QUANTITY REJECTED: 0

SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	ASTM B221
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	P0042405
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK.
RECORD RESULTS BELOW

	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS 61</u>		SIGNED OFF BY: _____	
DATE: <u>9-89 FEB 28 2019</u>		DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in